

*SPLIT*

Date: Thursday, 16/08/2007 12:01:09 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Jot Number	: 34032 -1	Part Number	: D28032
Estimate Number	: 11035	Drawing Number	: D2803 REV B
P.C. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 16/08/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 05/09/2007
Previous Run	: 33599	Qty:	30 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 00.11.06 New Issue EC Est Rev:B Blanks now cut on Waterjet 06-06-14 JLM		

## Additional Product

Jot Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total : 60.3761 f(s)  
6061-T6 Bar .50" x 10.0"  
Material: 6061-T6 bar 10.00" x 0.50" Batch: *M100285 X2*  
*M100741 X7*  
*M105145 X2 / B07-08-20*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Template DT8533  
Dwg Rev: *G*  
Prog Rev: *B*

*LB 07-08-20*

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per folio FA102

*GRK 07/11/26*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*GRK 07/11/26*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*GRK 07/11-26*

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 34032

Part Number: D28032

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr

J.L 07/11/27 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.L 07-11-27 ①

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-p

07/11/27

1X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: GA

80 07/11/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27 ①

Job Completion



U 07-11-27

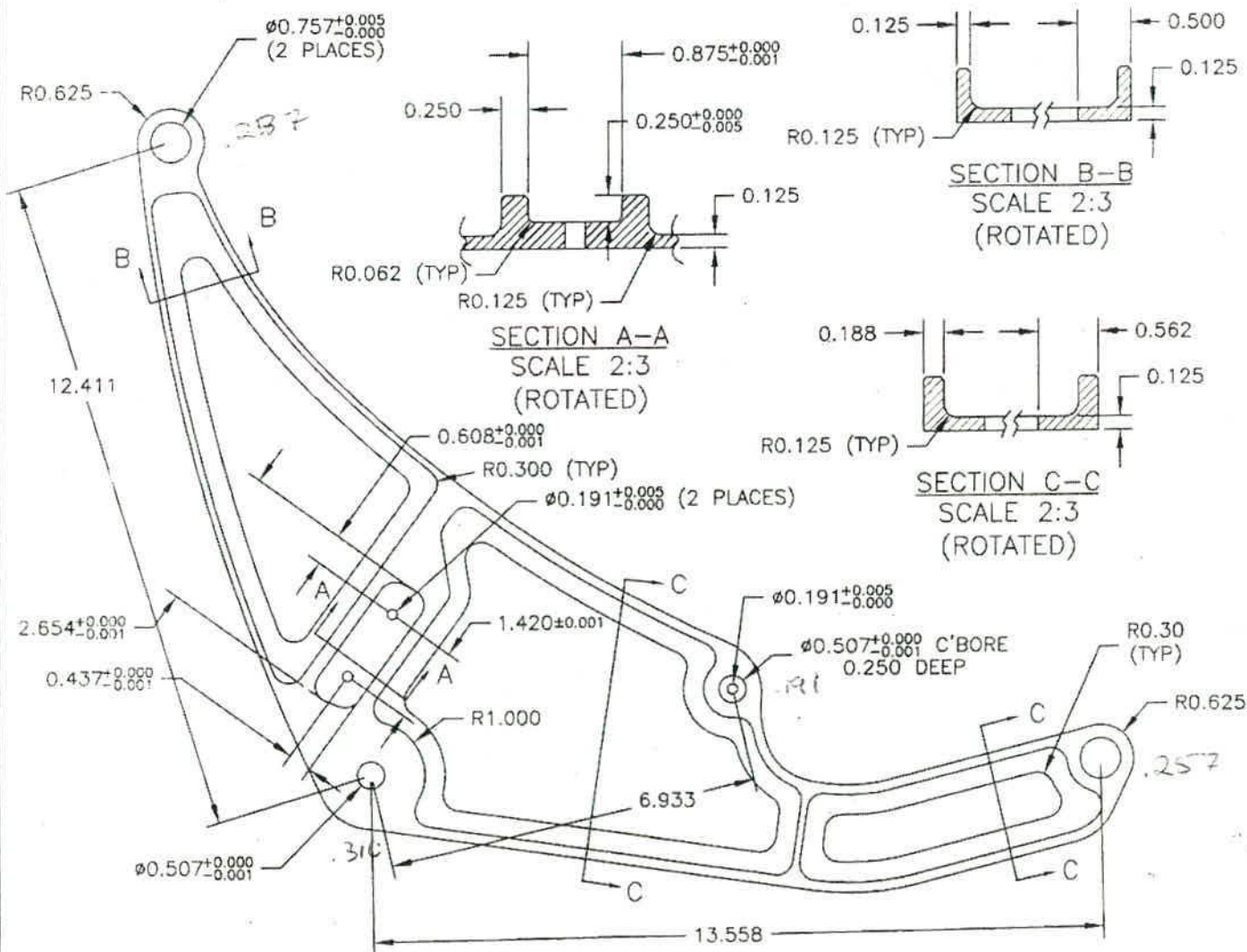




DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05 07 11



**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

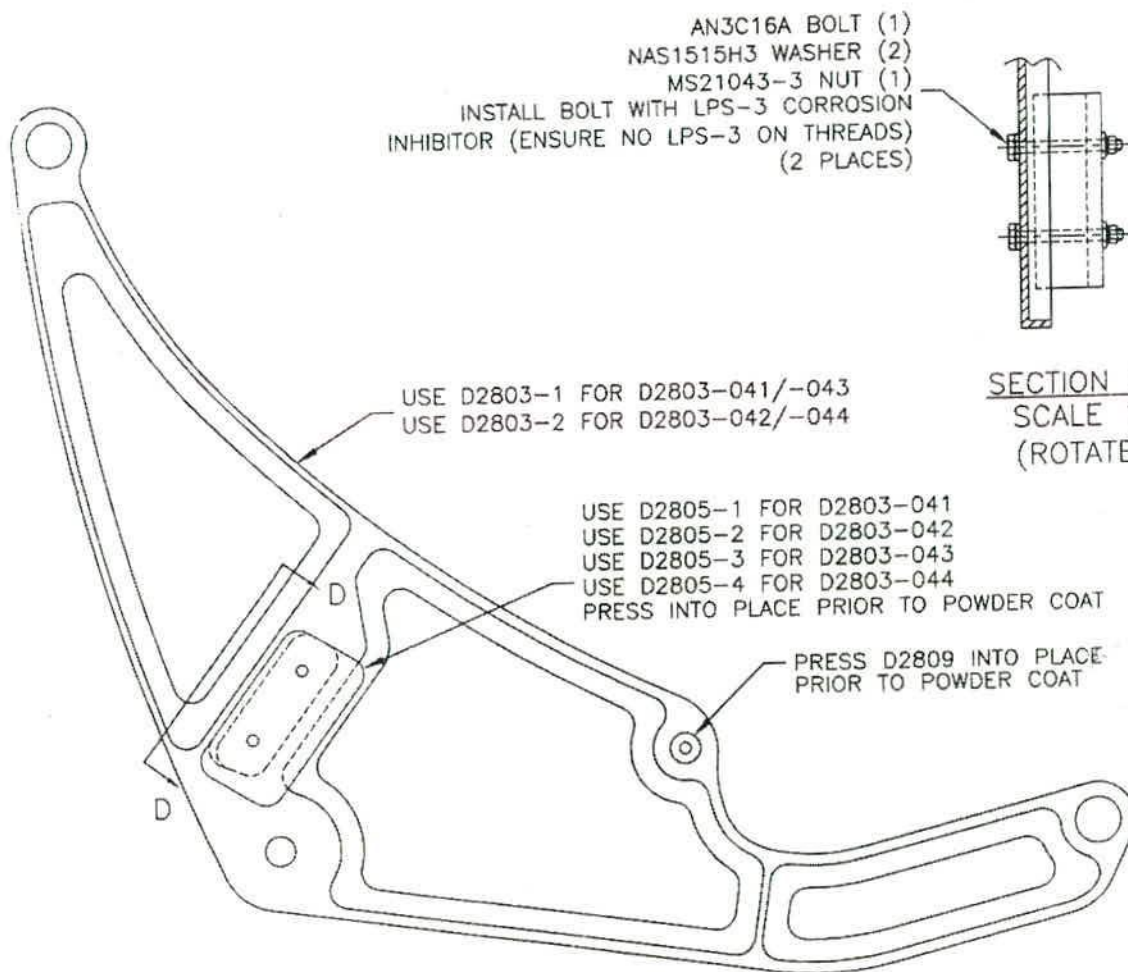
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W/O 34032



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	SHEET 2 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3



SECTION D-D  
SCALE 1:3  
(ROTATED)

RELEASED

05 03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34052
<b>Description:</b> Bracket		<b>Part Number:</b> D2803-2
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.7582	—			
1.420	+/-0.001	1.420	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
Ø0.507	+0.000/-0.001	Ø0.5064	—			
Ø0.507 x 0.250	+0.000/-0.001	Ø0.5065 x 0.250	—			
12.411	+/-0.010	12.411	—			
6.933	+/-0.010	6.930	—			
0.250	+/-0.010	0.257	—			
0.875	+0.000/-0.005	0.8745	—			
0.250	+0.000/-0.005	0.248	—			
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.124	—			
0.500	+/-0.010	0.501	—			
0.125	+/-0.010	0.125	—			
0.188	+/-0.010	0.195	—			
0.562	+/-0.010	0.563	—			
0.125	+/-0.010	0.125	—			

<b>Measured by:</b> JML	<b>Audited by:</b> JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/11/26	<b>Date:</b> 07/11/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	